

FORM PTO-1390
(REV 12-29-99)

U.S. DEPARTMENT OF COMMERCE PATENT AND TRADEMARK OFFICE

ATTORNEY'S DOCKET NUMBER

TRANSMITTAL LETTER TO THE UNITED STATES
DESIGNATED/ELECTED OFFICE (DO/EO/US)
CONCERNING A FILING UNDER 35 U.S.C. 371

41114

U.S. APPLICATION NO. (If known, see 37 CFR 1.5)

09/719009

INTERNATIONAL APPLICATION NO.
PCT/EP99/03862INTERNATIONAL FILING DATE
June 4, 1999PRIORITY DATE CLAIMED
June 12, 1998TITLE OF INVENTION
DEVICE FOR PRODUCING A RIVETED JOINT AND CORRESPONDING RIVETAPPLICANT(S) FOR DO/EO/US
SVEN ROTHE; KLAUS WIRTH

Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:

1. ☒ This is a **FIRST** submission of items concerning a filing under 35 U.S.C. 371.
2. ☐ This is a **SECOND** or **SUBSEQUENT** submission of items concerning a filing under 35 U.S.C. 371.
3. ☐ This express request to begin national examination procedures (35 U.S.C. 371(f)) at any time rather than delay examination until the expiration of the applicable time limit set in 35 U.S.C. 371(b) and PCT Articles 22 and 39(1).
4. ☒ A proper Demand for International Preliminary Examination was made by the 19th month from the earliest claimed priority date.
5. ☒ A copy of the International Application as filed (35 U.S.C. 371(c)(2))
 - a. ☒ is transmitted herewith (required only if not transmitted by the International Bureau).
 - b. ☐ has been transmitted by the International Bureau.
 - c. ☐ is not required, as the application was filed in the United States Receiving Office (RO/US).
6. ☒ A translation of the International Application into English (35 U.S.C. 371(c)(2)).
7. ☒ Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371(c)(3))
 - a. ☐ are transmitted herewith (required only if not transmitted by the International Bureau).
 - b. ☐ have been transmitted by the International Bureau.
 - c. ☐ have not been made; however, the time limit for making such amendments has NOT expired.
 - d. ☒ have not been made and will not be made.
8. ☐ A translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)).
9. ☒ An oath or declaration of the inventor(s) (35 U.S.C. 371(c)(4)).
10. ☐ A translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371(c)(5)).

Items 11. to 16. below concern document(s) or information included:

11. ☒ An Information Disclosure Statement under 37 CFR 1.97 and 1.98.
12. ☒ An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included.
13. ☒ A FIRST preliminary amendment.
☐ A SECOND or SUBSEQUENT preliminary amendment.
14. ☐ A substitute specification.
15. ☐ A change of power of attorney and/or address letter.
16. ☒ Other items or information:

Translation of Preliminary Examination Report

Applicant claims small entity status.

U.S. APPLICATION NO. (if known, see 37 CFR 1.5)		INTERNATIONAL APPLICATION NO.		ATTORNEY'S DOCKET NUMBER	
09/719009		PCT/EP99/03862		41114	

<p>17. <input checked="" type="checkbox"/> The following fees are submitted:</p> <p>BASIC NATIONAL FEE (37 CFR 1.492 (a) (1) - (5)) :</p> <p>Neither international preliminary examination fee (37 CFR 1.482) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO and International Search Report not prepared by the EPO or JPO \$1,000.00</p> <p>International preliminary examination fee (37 CFR 1.482) not paid to USPTO but International Search Report prepared by the EPO or JPO \$860.00</p> <p>International preliminary examination fee (37 CFR 1.482) not paid to USPTO but international search fee (37 CFR 1.445(a)(2)) paid to USPTO \$710.00</p> <p>International preliminary examination fee paid to USPTO (37 CFR 1.482) but all claims did not satisfy provisions of PCT Article 33(1)-(4) \$690.00</p> <p>International preliminary examination fee paid to USPTO (37 CFR 1.482) and all claims satisfied provisions of PCT Article 33(1)-(4) \$100.00</p> <p style="text-align: center;">ENTER APPROPRIATE BASIC FEE AMOUNT =</p> <p>Surcharge of \$130.00 for furnishing the oath or declaration later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492(e)).</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th style="width: 30%;">CLAIMS</th> <th style="width: 20%;">NUMBER FILED</th> <th style="width: 20%;">NUMBER EXTRA</th> <th style="width: 30%;">RATE</th> </tr> <tr> <td>Total claims</td> <td>9 - 20 =</td> <td>0</td> <td>X \$18.00</td> </tr> <tr> <td>Independent claims</td> <td>2 - 3 =</td> <td>0</td> <td>X \$80.00</td> </tr> <tr> <td colspan="3">MULTIPLE DEPENDENT CLAIM(S) (if applicable)</td> <td>+ \$270.00</td> </tr> </table> <p style="text-align: center;">TOTAL OF ABOVE CALCULATIONS =</p> <p>Reduction of 1/2 for filing by small entity, if applicable.</p> <p style="text-align: center;">SUBTOTAL =</p> <p>Processing fee of \$130.00 for furnishing the English translation later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492(f)).</p> <p style="text-align: center;">TOTAL NATIONAL FEE =</p> <p>Fee for recording the enclosed assignment (37 CFR 1.21(h)). The assignment must be accompanied by an appropriate cover sheet (37 CFR 3.28, 3.31). \$40.00 per property</p> <p style="text-align: center;">TOTAL FEES ENCLOSED =</p>	CLAIMS	NUMBER FILED	NUMBER EXTRA	RATE	Total claims	9 - 20 =	0	X \$18.00	Independent claims	2 - 3 =	0	X \$80.00	MULTIPLE DEPENDENT CLAIM(S) (if applicable)			+ \$270.00	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="2" style="text-align: left; font-weight: normal;">CALCULATIONS</th> <th style="text-align: left; font-weight: normal;">PTO USE ONLY</th> </tr> <tr> <td colspan="2" style="height: 150px; vertical-align: top;"> <p>\$ 860.00</p> <p>\$</p> <p>\$</p> <p>\$</p> <p>\$ 860.00</p> <p>\$ 430.00</p> <p>\$</p> <p>\$</p> <p>\$ 430.00</p> <p>\$ 40.00</p> <p>\$ 470.00</p> </td> <td></td> </tr> <tr> <td colspan="2"> <p>Amount to be refunded:</p> <p>charged:</p> </td> <td> <p>\$</p> <p>\$</p> </td> </tr> </table>	CALCULATIONS		PTO USE ONLY	<p>\$ 860.00</p> <p>\$</p> <p>\$</p> <p>\$</p> <p>\$ 860.00</p> <p>\$ 430.00</p> <p>\$</p> <p>\$</p> <p>\$ 430.00</p> <p>\$ 40.00</p> <p>\$ 470.00</p>			<p>Amount to be refunded:</p> <p>charged:</p>		<p>\$</p> <p>\$</p>
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a. ☒ A check in the amount of \$ 470.00 to cover the above fees is enclosed.

b. ☐ Please charge my Deposit Account No. _____ in the amount of \$ _____ to cover the above fees. A duplicate copy of this sheet is enclosed.

c. ☒ The Commissioner is hereby authorized to charge any additional fees which may be required, or credit any overpayment to Deposit Account No. 18-2220. A duplicate copy of this sheet is enclosed.

NOTE: Where an appropriate time limit under 37 CFR 1.494 or 1.495 has not been met, a petition to revive (37 CFR 1.137(a) or (b)) must be filed and granted to restore the application to pending status.

<p>SEND ALL CORRESPONDENCE TO</p> <p>Roylance, Abrams, Berdo & Goodman, L.L.P.</p> <p>1300 19th Street, N.W., Suite 600</p> <p>Washington, D.C. 20036</p> <p>(202) 659-9076</p>	<p>SIGNATURE</p> <p>Mark S. Bicks</p> <p>NAME</p> <p>28,770</p> <p>REGISTRATION NUMBER</p>
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In re Application of :
SVEN RÖTHE ET AL. : PATENT
Serial No.: New : Group Art Unit:
Filed: Herewith : Examiner:
For: DEVICE FOR PRODUCING A RIVETED :
JOINT AND CORRESPONDING RIVET :

PRELIMINARY AMENDMENT

Commissioner for Patents
Washington, D.C. 20231

Sir:

Preliminary to examination and calculation of the filing fee, please amend the above-identified application, as amended in the Preliminary Examination, as follows:

Claim 3, line 1, change "Claim 1 or 2" to -- claim 1 --.


Claim 4, line 1, change "one of the Claims 1 to 3" to -- claim 1 --.

Claim 7, line 1, change "one of the Claims 4 to 6" to -- claim 4 --.

REMARKS

The above changes eliminate multiple dependency in the claims.

Respectfully submitted,



Mark S. Bicks
Reg. No. 28,770

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1300 19th Street, N.W.
Washington, D.C. 20036
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Dated: Dec. 6, 2000

Device for Producing a Riveted Joint and Corresponding Rivet

The invention relates to a device for producing a riveted joint with means for firing the rivet and means for pulling the rivet as disclosed in the disclosure part of Claim 1 as well as a rivet suitable for use with this device.

Riveted joints of this type are already known and used for the joining of workpieces, especially sheets of metal, particularly when the workpieces to be joined are accessible from only one side. Typical uses of the riveted joint are the assembly of metal fittings, walls of cassettes or disk holders or border parts on insulation panels in industry and in the construction of large halls or gymnasiums. The sheet metal pieces to be joined are of a thickness of approximately 0.1 mm to approximately 3 mm, and typically approximately 0.75 mm.

For the mounting of the rivet, made up of a rivet jacket and a rivet pin guided through the rivet jacket, the workpieces are first penetrated and the rivet with rivet jacket is pressed forward and through as far as impact of the striking head of the rivet jacket on the edge of the borehole inside the borehole. For production of the riveted joint between the workpieces then with holding back of the striking head the rivet pin is drawn counter to the pressing-in direction, whereby the end of the rivet jacket lying opposite the striking head is deformed, allowing for the formation of a widened out part, so that the workpieces to be joined together are held together between the striking head and the widening out which has been produced. This type of the riveting is frequently also known as "blind riveting." EP 0 302 128 B1 discloses a tool for drawing out or setting of blind rivets. Even with use of such a tool a preliminary borehole and insertion of the blind rivet is still required.

WO 95/05255 shows a device for production of a riveted joint with pneumatically driven means for the firing of a rivet through the workpieces to be joined and pneumatically driven means for the subsequent pulling of the rivet. The means for the firing of the rivet in this case incorporate a conically tapering, hollow cylindrical driving-in part on the striking head of the rivet jacket. The rivet pin is guided through an opening in the striking surface of the driving-in part which is turned toward the striking head of the rivet in the interior of the driving-in part, and at that point is picked up by the means arranged to the rear of the driving-in part in the firing direction for the pulling of the rivet. The outlay for construction required by the arrangement of the means for the pulling of the rivet within the hollow cylindrical volume formed by the means for the firing of the rivet is considerable for such a device, especially because it requires the reliable operation of such a device while using high quality materials and also requires the maintenance of low manufacturing tolerances with reference to the means for pulling the rivet. Also this arrangement requires a large structure for the entire assembly.

The object of the present invention relates to the problem of manufacturing a device for producing a riveted joint which can be manufactured at low cost and which still guarantees reliable operation. The outlay for construction for the manufacture and preparation of means for the firing of the rivet is therefore to be held as low as possible, and a realization with smaller structural dimensions than is customary is to be possible. Also a rivet is to be developed and manufactured which can be processed using this device.

The problem is solved by the device disclosed in Claim 1. A suitable rivet is described in Claim 10. Specific embodiments of the invention are described in the dependent claims.

The problem is solved using a device as in Claim 1 in that the means for the driving-in or pulling of the rivet act on the rivet pin. Thus it is possible that the means for the pulling of the rivet

engage advantageously in the firing direction before the means for the firing of the rivet on the rivet pin. The constructive configuration showing room for some play in the realization of the means for pulling of the rivet is then more extensive and at the same time a suitable device can be realized which is small and easy to manufacture. The firing of the rivet by means of force being applied to the rivet pin also heightens the reliability of the riveted joint which is then produced, since a sure penetration of the workpieces to be joined by means of the rivet pin is then guaranteed. The means for firing the rivet and means for pulling the rivet can be powered pneumatically, hydraulically, magnetically, electrically, piezoelectrically or with use of explosive means.

The device according to Claim 2 offers the advantage that the reliability of the firing process and with that the reliability of the riveted joint itself is heightened by the interposition of a cylindrical striking member between the firing bolt and the rivet. The striking member can thus be made up of a first segment of which the diameter is adapted to the diameter of the firing channel and a second segment of which the smaller diameter is adapted to the diameter of the rivet pin, and particularly can be of approximately identical diameter up to 1.5-times the diameter of the rivet pin.

The device as in Claim 3 offers the advantage that the reliability of the firing process is further heightened by the centering device which may be synclinal and is adapted to the end of the rivet pin turned toward the striking member. Of particular importance, the traditionally desirable rectangular alignment of the rivet pin in relation to the workpieces to be joined and the corresponding guiding of the rivet during the firing process is guaranteed.

The device according to Claim 4 has the advantage that the striking member is already engaged on the rivet pin when the firing bolt impacts on the striking member. Thus any damage,

especially bending, of the rivet pin and of the striking member because of an impact of the striking member on the rivet pin is reliably prevented. Furthermore a falling of the torn-off rivet pin into the firing channel is thus also prevented, and the device can be operated in any setting, especially in that rivets can even be set up facing upward.

The device according to Claim 5 offers the advantage that the movement of the striking member at the end of the firing process is smoothly suppressed by the flexible buffer element and especially does not impinge on the end of the firing channel which is preferably of metallic configuration. The service life of the device is thus significantly increased. The buffer element preferably engages on an annular shoulder at the end of the firing channel which is formed by an opening in the firing channel, and the buffer can for example be configured as helical spring, disk spring or rubber or plastic washer.

The device of Claim 6 offers the advantage that the firing channel can be made easily accessible as a result of the two-part configuration of the firing channel formed by a hollow piston and a connecting member, which preferably are screwed together, and especially in that case the striking member can be exchanged when necessary.

The device according to Claim 7 offers the advantage that not only is the guiding of the rivet pin during the firing and pulling process obtained through the end piece, but that the end piece simultaneously executes a spreading of the clamping jaws during the firing process and with that allows a friction-free passage of the rivet pin and if necessary of the striking member through the clamping jaws during the firing process. Any damage to the clamping jaws and potentially to the striking member is simultaneously and reliably prevented by the rivet pin during the firing process. Also the introduction of a new rivet is simplified by the spreading of the clamping jaws. The second flexible element can be configured as a helical spring. Alternatively to that for

example a disk spring or a rubber or plastic washer can be used.

The device according to Claim 8 offers the advantage that by having the piston, joining member and clamp sheathing connected with one another, preferably by being screwed together with one another, a pulling of the rivet pin by means of the stress of the pressure of the piston counter to the force effect of a flexible element, preferably a helical screw with high elasticity constant, a reliable pulling of the rivet and with that a reliable production of the riveted joint are guaranteed. The pressure is preferably applied by using hydraulic pressure in order to generate the required high pressure forces.

The device as in Claim 9 offers the advantage that the device requires only one auxiliary connection, which is a compressed air connection. The preparation of the hydraulic pressure occurs through a pneumatic/hydraulic pressure converter. The rivet is fired pneumatically; the rivet is pulled off hydraulically. The entire riveting process including firing and pulling is controlled by a three-stage pneumatic switch element. The pneumatic/hydraulic pressure converter the same as the rapid evacuation or pressure release valve is preferably mounted in a handle of the device.

A rivet is described in Claim 10 for use in the device according to the invention. Here it is proven advantageous that the rivet jacket be connected securely with the rivet pin, preferably by being extruded thereon. Thus it is assured that the rivet pin will not be moved or at least will not be moved remarkably relative to the rivet jacket especially during the firing process. This is especially advantageous with use of the rivet in a device according to the invention, since with the device of the invention the means for firing the rivet act on the rivet pin. The rivet pin is preferably of steel or stainless steel. The rivet jacket can likewise be of steel or stainless steel or alternatively can be of an aluminum or copper alloy.

The rivet of Claim 11 offers the advantage that by the shaping of a point, penetration of the workpiece is possible even with low firing power. The point can thus be configured conical or if desired can be ogival, and more particularly the point can also have one or more cutting edges. The point angle configuration is preferably in a range of between 30 and 60°.

The rivet of Claim 12 has the advantage that a total of four cutting edges are formed by the pyramid configuration, which simplifies the penetration of workpieces.

The rivet as in Claim 13 has the advantage that cooperation with the centering device on the striking member is specifically guaranteed by the tapering second end of the rivet pin. A configuration of the second end in the shape of a pyramid is advantageously obtained by suitable separation of a rivet pin from a rod-shaped starting material.

The rivet according to Claim 14 has the advantage that by the provision of catching means directed toward the point of the rivet, any relative movement of the rivet pin in relation to the rivet jacket especially during the firing process of the rivet is reliably prevented. The catching means then can for example be realized by pins extending radially and distributed around the periphery of the rivet pin or by partial segments of the rivet pin which are truncated conically-shaped, arranged one behind the other in axial direction, and produced by rollers.

Other advantages, features and individual points relating to the invention are disclosed in the dependent claims as well as the following description with reference to the drawings showing one exemplary embodiment in some detail. Thus the selected features indicated in the claims and in the description can be protected individually in turn in and of themselves or in any desired combination considered as relating to the invention.

- Fig. 1 shows a section through the head part of the device according to the invention,
 Fig. 2 shows a section through the handle of the device according to the invention,
 Fig. 3 shows a diagrammatic and partially cutout view of the entire device according to the invention, and
 Fig. 4 shows a rivet for use in the device according to the invention.

Fig. 1 shows a section through the head part of the device according to the invention, which device is responsible for the firing and pulling of the rivet. The housing 1 of the device is represented at the right edge of the drawing, on which housing with use of a first packing O-ring 2 and a glass shield 24 the first cylinder 22 is screwed on by means of cylindrical screw 6 and supporting disks or washers 23. Likewise on the right edge of the drawing is represented the pneumatic cylinder 58 with the firing bolt 25 and the first buffer 50. Firing channel 70 extends in axial extension of firing bolt 25 and is formed by the centering member 45, the hollow piston 20 and the joining member 18. Piston 20 is screwed together with joining member 18 and is connected with the centering member 45 by a close adaptation of the play and under the effect of force from the third helical spring 8 configured as the third flexible element. Piston 20 is supported by means of third helical spring 8, which is supported at one end on the glass shield 24 and on the other end on centering member 45, prebiased in the direction of the rivet 14 represented at the left edge of the drawing.

Piston 20 is guided in first cylinder 22 by a guiding ring 13 and a first packing/sealing combination 12 and is sealed. On hydraulic connection 69, hydraulic power fluid is guided through an annular groove and corresponding bores into the first guide bushing 26 on a retaining ring 5 and into the hollow cylindrical volume between first cylinder 22 and piston 20, and piston 20 can be moved with corresponding pressure stress application of for example 200 Bar counter to effect of third helical spring 8 in first cylinder 22. Another hydraulic connection of first

cylinder 22 is plugged blind by the first screw 56. Piston 20 is guided and sealed by a second seal-forming combination 11 and a third O-ring 10 arranged axially adjacent to that arrangement on the rivet-side end of first cylinder 22. The seal-forming combinations 11, 12, 35 are of multiple parts and have a plastic part with a packing washer and a O-ring mounted thereunder.

Piston 20 is screwed together with the joining member 18 with use of a locknut 19. Into firing channel 70 formed by aligned boreholes in piston 20 and connecting piece 18 is guided a striking member 21, which is prebiased in the direction of rivet 14 by the first helical spring 51 embodied as first flexible element. First helical spring 51 is thus supported in the direction of housing 1 on an annular shoulder formed in the firing channel by piston 20 and is supported in the direction of rivet 14 on striking member 21. Striking member 21 at its end turned toward first helical spring 51 likewise has an annular shoulder formed by building up of a cylindrical extension with a small diameter, on which is supported first helical spring 51.

Striking member 21 can be configured of one or more pieces, especially of two pieces. In the case of a two-piece configuration, striking member 21 can consist of a jacket and a pin introduced into the jacket and connected securely with it, which pin has a smaller diameter, a greater length and a higher flexibility module and/or a greater hardness than the jacket. The secure connection between jacket and pin can be executed for example by welding, extrusion or by use of adhesive. The diameter of the jacket is adapted to the diameter of firing channel 70, while the diameter of the pin is adapted to the diameter of the rivet pin 14b.

In the position shown in the drawing, striking member 21 engages on a buffer element 49 arranged at the end of firing channel 70. Firing channel 70 is open through a borehole in joining member 18 to rivet 14, whereby in the exemplary embodiment shown in the drawing the striking member 21 has a first segment 21a of which the diameter is adapted to the diameter of firing

channel 70 and by means of which striking member 21 is guided in firing channel 70, and also has a second segment 21b, of which the smaller diameter is adapted to the diameter of the bore in joining member 18 or to the diameter of rivet pin 14b.

Joining member 18 is sealed in and guided within a guiding jacket 16 screwed together with first cylinder 22 with a second O-ring 9 inserted in an annular groove. Furthermore a clamp sheathing 4 is screwed together with joining member 18, which sheathing surrounds clamping jaws 3 arranged around rivet pin 14b and likewise is guided into the guiding sleeve 16. Clamping jaws 3 are spread at their end turned toward housing 1 by means of a pressure sheathing 17, which is prebiased under the effect of a second helical spring 7 arranged between pressure sheathing 17 and joining member 18 in the direction of rivet 14, and at its end turned toward rivet 14 is spread apart by means of an end piece 15 screwed into guiding sleeve 16. The spreading then is executed by form-locking contact of conical contact surfaces of clamping jaws 3 and pressure sheathing 17 or end piece 15.

Second segment 21b of striking member 21 projects into the position represented in the drawing through the bore of joining member 18 and a bore in pressure sheathing 17 until it reaches between clamping jaws 3 and engages on rivet pin 14b of rivet 14. At its end adjacent to rivet pin 14b, second segment 21b is shaped in a synclinal depression serving as centering device for rivet pin 14b.

Guiding sleeve 16 is surrounded by a centering sleeve 54, which has an opening in alignment with the borehole in end piece 15 to receive rivet pin 14b. Centering sleeve 54 is tightly connected over first screw 52 and centering sleeve 54 or to the second rod 57, preferably welded thereto, nuts 53 connect with a first rod 55 and a second rod 57, while rod 57 acts on a switch element of the device in such a manner that the firing process cannot be triggered until the

centering sleeve 54 is moved by a suitable contact force on the device with contact of rivet 14 to the workpieces to be joined as well as to centering sleeve 54, moving axially in the direction of housing 1 through guiding sleeve 16 and engages thereon. Thus both the risk of injury by firing of a rivet without suitable contact on a workpiece and also blank firing and the risk of damage to the device connected therewith are effectively minimized.

Fig. 2 shows a section through the handle 71 of the device of the invention. Through the compressed air connection 68 the device is supplied with compressed air for example at 7 Bar pressure. The process of firing and pulling is controlled by means of a pneumatic switch element surrounding the firing valve 59, pulling valve 60 and outlet 61. The active pneumatic/hydraulic pressure converter during the pulling of the rivet is triggered by means of a not shown connection between pulling valve 60 and input connection 67 in the covering 34 with compressed air. The not shown connection can for example be realized through compressed air tubes guided outside of the handle or by compressed air tubes or compressed air channels guided within the handle.

Covering 34 furthermore surrounds a rapid evacuation valve, which includes a sliding seal 48 and a member 46 sealed by means of a ninth O-ring 64 and having an axial borehole. On the output side of the rapid evacuation valve is provided a screen 47 secured with a second security ring 63, in order to prevent contamination of the rapid evacuation valve. Connection of the rapid evacuation valve with the second cylinder 32 of the pneumatic/hydraulic pressure converter is provided through a borehole in covering 34. Covering 34 is connected with use of a sealing flange 33 screwed together with it and seventh and eighth O-rings 39 and 62 with the second cylinder 32.

Within second cylinder 32 is arranged a pneumatic piston 31 which is sealed off from the wall of second cylinder 32 by means of a sixth O-ring 38 introduced into an annular groove. A piston

rod 27 is connected with pneumatic piston 31, and with use of a third sealing combination 35 and a fifth O-ring 37 piston rod 27 moves through a flange 30 and enters into a hollow space 66 filled with a hydraulic fluid. Piston rod 27 is also guided by a guiding bushing 29 arranged between guiding flange 30 and handle 71. With an upward movement of pneumatic piston 31 and concomitantly with the piston rod 27 movement being reversed, the pneumatic pressure at the input connection 67 is converted into hydraulic pressure in hollow space 66. The hydraulic pressure is guided through output connection 65 to the hydraulic connection 69 shown in Fig. 1. The not shown pressure guide on the hydraulic side can in turn for example be guided by pressure lines from outside the handle or the device can be realized by pressure lines or pressure channels guided within the device.

Guiding flange 30 is screwed by means of the second screw 40 together with handle 71 with use of a fourth O-ring 36 and sealed tightly. At the same time by means of exterior threading, flange 30 is screwed together with the second cylinder 32. Furthermore an annular second buffer 44 is provided on flange 30 for the buffering of pneumatic piston 31 in the case of an upward movement.

The following functions take place during the production of a riveted joint : first of all as shown in Fig. 1 a rivet is introduced into the device until rivet pin 14b engages on striking member 21. In this state the firing process has not yet been triggered, since the centering sleeve 54 in the position shown in Fig. 1 does not yet release or disengage from the pneumatic switch element 59, 60, 61. Finally the device having rivet pin 14b is pressed against the workpiece to be joined. Then rivet pin 14b is first introduced counter to the effect of the first helical spring 51 by the clamping jaws 3 in the opening of joining member 18 and thus the striking member 21 is pressed to the rear in firing channel 70. The striking head 14e of rivet sleeve 14a thus comes into contact with centering sleeve 54 and moves this sleeve with further pressing in the direction of guiding

sleeve 16, whereupon the pneumatic switch element 59, 60, 61 is disengaged by means of the first and second rods 55, 57.

During the operation of the first switch step, firing bolt 25 is slipped forward by centrifugal action and impacts on striking member 21, which then acts on rivet pin 14b and fires rivet 14 into the workpieces to be joined. The forward movement of striking member 21 is then buffered by the buffer element 49 within firing channel 70.

With further pulling through of the outlet 61 shown in Fig. 2, by means of the pulling-valve 60, the pneumatic/hydraulic pressure converter is acted upon with compressed air coming through input connection 67. The seal 48 thus engages on insert member 46 and frees the passage of compressed air on pneumatic piston 31, which is moved upward and builds up a pressure in the hollow space 66 over piston rod 27, and the pressure is fed through the output connection 65 to hydraulic connection 69 shown in Fig. 1.

The hydraulic pressure works on piston 20 and presses it counter to the force of third helical spring 8 in the direction of housing 1. Thus clamp sheathing 4 is also pulled in the direction of housing 1 and clamping jaws 3 engage rivet pin 14b tightly and tear it rearward to a predetermined break point. With release of outlet 61, the input connection 67 shown in Fig. 2 is without pressure, whereupon the seal 48 of member 46 drops away and the passage for the compressed air is released from second cylinder 32 through member 46 and screen 47 leading to the outside environment. Second cylinder 32 is then without pressure. Under the effect of third helical spring 8, piston 20 in its original setting is pressed in the direction of rivet 14 and through hydraulic connection 69 and output connection 65, piston rod 27 and along with that pneumatic piston 31 is moved back into its bottom original position. Simultaneously by the movement of piston 20 in the direction of rivet 14 by means of second segment 21b of striking member 21 the

torn away rivet pin 14b is thrown out forward by clamp sheathing 4 and guiding sleeve 16. The device is now ready for the insertion of another rivet and for the repeated production of a riveted joint.

The mechanism of pneumatic switch elements 59, 60, 61 and of second rod 57 arranged in working connection with the switch is designed so that firing bolt 25 following an act of firing preferably returns to its original setting and multiple triggerings of the pulling process without cyclical firing processes is possible, as long as the machine has not been removed from the workpieces to be joined. This advantageously allows for multiple pullings of a rivet which has been fired in and therefore increases both the reliability and the operational security of the device.

Fig. 3 shows a diagrammatic and partially sectioned total view of the device of the invention. The position of rivet 14 which is shown in relation to centering sleeve 54 and therefore thus on the head of the device corresponds to the representation of Fig. 1. The position of pneumatic piston 31 in handle 71 corresponds to the representation in Fig. 2. The compressed air conduit 72 is represented by a broken line between the pulling valve 60 and the input connection 67. The hydraulic pressure line 73 is represented by a broken line between output connection 65 and hydraulic connection 69.

Fig. 4 shows a rivet for use in the device of the invention. Rivet 14 is constructed in two parts and has a rivet jacket 14a and a rivet pin 14b. Rivet pin 14b is provided at its first end directed to the workpieces to be joined with a point 14c and with cutting edges 14d. Having a pyramid shape of the first end of rivet pin 14b has been shown as especially advantageous, whereupon all four cutting edges 14d are formed. Rivet pin 14b is surrounded in segments by rivet jacket 14a, whereby rivet jacket 14a on its end more distant from point 14c is configured as mushroom-shaped and forms a striking head 14e. At the end 14g opposite this point 14c rivet pin 14b is

likewise configured preferably in pyramid shape, in order to guarantee reliable centering in relation to the striking member 21.

With the firing of rivet 14, rivet pin 14b together with rivet jacket 14a is driven sufficiently far into the workpieces which are to be joined until striking head 14e engages on a workpiece to be joined. In order to prevent penetration of rivet pin 14b, rivet pin 14b has catching means in the area of rivet jacket 14a directed in the direction of the point 14c of rivet 14. These means can for example be formed by saw-toothed, rolled-in annular grooves, whereby the sawtooth shape is aligned so that during the firing of rivet 14 rivet pin 14b hooks into the rivet jacket. In the area of this catching means rivet jacket 14a is connected tightly with rivet pin 14b, for example is extruded, soldered, cemented or welded with it. Therefore rivet pin 14b in the area of rivet jacket 14a has a predetermined break point 14f, from which rivet pin 14b tears away during pulling of rivet 14.

Patent Claims

1. Device for producing a riveted joint with means (21, 25) for the driving-in of a rivet (14) having a rivet jacket (14a) and a rivet pin (14b) guided by the rivet jacket (14a) through workpieces to be joined and with means for the pulling of the rivet (14), **characterized in that** the means (21, 25) for the driving-in of the rivet (14) act on the rivet pin (14b).
2. Device as in Claim 1, characterized in that the means (21, 25) for the driving-in of the rivet (14) into a cylindrical part, especially into a firing channel (70), include a firing bolt (25) and a cylindrical striking member (21) arranged between the rivet (14) and the firing bolt (25), and the striking member (21) impacts on the firing bolt (25).
3. Device as in Claim 2, characterized in that the striking member (21) has a centering device for the rivet pin (14b) on its end turned toward the rivet (14).
4. Device as in Claim 2 or 3, characterized in that the striking member (21) is held in the cylindrical part by a first flexible element, especially by a first helical spring (51), in axial contact on the rivet pin.
5. Device as in one of the Claims 2 to 4, characterized in that on the end of the cylindrical part turned toward the rivet (14) is arranged a flexible buffer element (49), which buffers the movement of the striking member (21) during driving-in of the rivet (14).
6. Device as in one of the Claims 2 to 5, characterized in that the cylindrical part is formed by boreholes in alignment in a piston (20) and in a joining member (18) joining with the piston (20).
7. Device as in Claim 6, characterized in that the means for pulling the rivet (14) include a clamp sheathing (4) connected with the joining member (18), which surrounds the clamping jaws (3) arranged around the rivet pin (14b), and that the clamp sheathing (4) and the joining member (18) are guided in a guiding sleeve (16), in the axial end of which turned toward the rivet (14) is inserted an end piece (15) provided with a borehole in the center to receive the rivet pin (14b), which end piece spreads the clamping jaws (3)

engaging on it before and during the driving-in under the effect of a second flexible element (7).

8. Device as in Claim 7, characterized in that the piston (20) can be moved in a cylinder (22) connected with the guiding sleeve (16) during pulling of the rivet (14), the piston being moved counter to the driving-in direction through pressure application coming from the piston (20) counter to the effect of the force of a third flexible element (8).
9. Device as in one of the Claims 5 to 8, characterized in that the device has a compressed air connection (68) and a multi-stage pneumatic switch element (59, 60, 61), which in a first switch stage fires the firing bolt, in a second switch stage feeds the compressed air to a pneumatic/hydraulic pressure converter preferably mounted in a handle (71) of the device, which makes ready the pressure stress application of the piston (20) during pulling of the rivet, and in a third switch stage evacuates the pneumatic/hydraulic pressure converter by means of a rapid evacuation valve.
10. Rivet for use in a device as in one of the Claims 1 to 9, characterized in that the rivet pin (14b) is connected tightly with the rivet jacket (14a).
11. Rivet as in Claim 10, characterized in that the rivet pin (14b) at its first end turned toward the workpieces has a point (14c).
12. Rivet as in Claim 11, characterized in that the first end is of pyramid shape.
13. Rivet as in one of the Claims 10 to 12, characterized in that the rivet pin (14b) is tapered at its second end (14g) more distant from the workpieces, preferably tapered in a pyramid shape.
14. Rivet as in one of the Claims 10 to 13, characterized in that the rivet pin (14b) includes catching means in the area of the rivet jacket (14a) aligned toward the point (14c) of the rivet (14).

INTERNATIONAL COOPERATION AGREEMENT

PATENTS

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INTERNATIONAL PRELIMINARY EXAMINATION REPORT

(Article 36 and Rule 70 PCT)

Identification of Applicant or Attorney : 10hww/128478/PCT
International File : PCT/EP99/03862
International Application Date : June 4, 1999
Priority Date : June 12, 1998

FURTHER PROCEDURES

see notification of the transmittal of the international preliminary examination report (Form PCT/IPEA/416)

International Classification (IPC) or national classification and IPC : B21J15/04

Applicant : WIRTH MASCHINENBAU GMBH et al

1. This international preliminary examination report was originated from the governmental authority commissioned with the international preliminary examination and is transmitted to the applicant under Article 36.

2. This **REPORT** covers 5 pages including this cover page.

/X/ **ATTACHMENTS** are attached to the Report; the sheets of the attachments include descriptions, claims and/or drawings, which were modified and are part of this Report, and/or sheets with amendments undertaken before this governmental authority (cf. Rule 70.16 and Section 607 of the Attorneys Instructions for the PCT).

This attachment includes 11 pages.

3. This report includes data on the following points :

- | | | |
|------|-----|--|
| I | /X/ | Basic report |
| II | / / | Priority |
| III | / / | No note of an expert opinion regarding novelty, inventive concept and commercial applicability |
| IV | / / | Defective uniformity of the invention |
| V | /X/ | Basic findings from Article 35(2) with regard to novelty, inventive concept and commercial applicability; reasons and explanation in support of these findings |
| VI | / / | Certain cited data |
| VII | / / | Certain deficiencies of the international application |
| VIII | / / | Certain remarks regarding the international application |

Date of Filing Petition for Preliminary Examination: December 8, 1999

Date of completion of this Report : August 28, 2000

European Patent Office
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[Rubber stamp]

INTERNATIONAL PRELIMINARY EXAMINATION REPORT

International File PCT/EP99/03862

I. Basic Report

1. This report was drafted upon review of the basic data (Replacement sheets which were submitted upon request pertinent to Article 14 serve in this report as "originally filed" and are not attached thereto, because they include no modifications.)

Description, pages :

1, 8-15	original draft	
2-7,7a-7b	filed on	July 6, 2000 with correspondence from July 5, 2000

Patent claims, No. :

1-9	filed on	July 6, 2000 with correspondence from July 5, 2000
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Drawings, sheets :

1/4-4/4	original draft
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2. With the following modifications :

3. ...[modifications]

4. ...[additional remarks]

INTERNATIONAL PRELIMINARY EXAMINATION REPORT
International File PCT/EP99/03862

III. No finding of a technical opinion concerning novelty, inventive concept and commercial utility

The following sections of the application were not providing proof regarding whether the claimed invention is to be assumed to be novel, based on inventive concept (not obvious) and of commercial utility :

// the entire international application

/X/ Claims Nos. 8, 9.

Reason :

// The entire international application or the aforementioned claims . . .

/X/ The description, the claims or the drawings (indicate hereinafter precisely which) or the aforementioned Claim No. 8 are so unclear that no meaningful technical opinion could be formed (precise data) :

see Attachment

// Claims . . .

// Claims

V. Substantiated determination under Article 35(2) regarding the novelty, the inventive concept and the commercial applicability; data and explanations in support of this determination

1. Determination

Novelty (N)	Yes :	Claims 1-7
	No :	

Inventive Concept (ET)	Yes :	Claims 1-7
	No :	

Commercial Applicability (GA)	Yes :	Claims 1-7
	No :	

2. Cited references and explanations

see Attachment

**INTERNATIONAL PRELIMINARY EXAMINATION REPORT
ATTACHMENT**

International file PCT/EP99/03862

Regarding No. III :

See point V, paragraph 4.

Regarding No. V :

The following documents are cited :

D1 : GB - A-1 128 442

D2 : DE-U-295 12 392

2. Independent Claim 1 :

The object of Claim 1 differs from D1, which is assumed as anticipatory state of the art, by the features included in the characterizing disclosure part.

Owing to the fact that the striking member is held permanently in axial alignment on the rivet pin, an impacting of the striking member on the rivet pin is avoided. The problem which is thus solved resides in preventing a bending of either the rivet pin or the striking member, which with it contributes a higher degree of operational security and a longer life of the device.

No documents disclosing the state of the art disclose the different feature disclosed for the solution of the aforementioned problem.

The object of Claim 1 is novel and of inventive concept (Article 33(2) PCT).

3. Dependent Claims 2 to 7 :

The objects of Claims 2 to 7 disclose other configurations of the device according to Claim 1, and they are therefore likewise novel and of inventive concept (Article 33(2) and 33(3) PCT).

4. Independent Claim 8 and dependent Claim 9 :

The object of Claim 8 is unclear because of the expression "catching means aligned on the point of the rivet" (Article 6 PCT). Such an alignment of the catching means can be understood only in such a manner that the catching means is tapered in the direction of the point of the rivet and thus cause a catching with the rivet jacket during pulling of the rivet. Figure 4 however shows catching means aligned on the end of the rivet, which means are caught during firing with the device as in Claim 1, and not during the pulling of the rivet in the rivet jacket. That a catching during firing is intended is also disclosed in the description of the exemplary embodiment as described on page 15, lines 20 - 23.

However in turn for example with exactly the following wording, corresponding to the exemplary embodiment on page 15, saying

...that the rivet pin in the area of the rivet jacket has sawtooth catching means, whereby the sawtooth shape is aligned such that the rivet pin is caught during firing of the rivet into the rivet jacket,

the alignment of the catching means would be unclear. With the firing-in of the rivet using the device as in Claim 1, in other words with operation of the means for the driving-in of the rivet on the rivet pin, the catching means would have to be aligned on the end of the rivet, during the firing-in with a device such as that shown in D2, Figure 4, in other words during operation of the means for the driving-in of the rivet on the rivet jacket, on the point of the rivet. The rivet as in Claim 8 however is intended to be suitable for use in any known device for producing a rivet joint with means for the driving-in of the rivet which are not described in greater detail, including both the device of Claim 1 and also the known device from D2. However, according to which device is being used for the firing-in of the rivet then also the alignment of the catching means must be modified accordingly.

It is not distinguishable in what manner could occur any clarification of Claim 8.

From the facts as assumed no opinion regarding the novelty and inventive concept of the objects of Claims 8 and 9 can be provided.

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.... This type of rivet is frequently also called a "blind rivet". EP 0 302 128 B1 shows a tool for the pulling or setting of blind rivets. Also with use of such a tool a preliminary borehole and insertion of the blind rivet are still required.

WO 95/05255 shows a device for production of a riveted joint with pneumatically driven means for the firing of a rivet through the workpieces to be joined and pneumatically driven means for the subsequent pulling of the rivet. The means for the firing of the rivet in this case incorporate a conically tapering, hollow cylindrical driving-in part on the striking head of the rivet jacket. The rivet pin is guided through an opening in the striking surface of the driving-in part which is turned toward the striking head of the rivet in the interior of the driving-in part, and at that point is picked up by the means arranged to the rear of the driving-in part in the firing direction for the pulling of the rivet. The outlay for construction required by the arrangement of the means for the pulling of the rivet within the hollow cylindrical volume formed by the means for the firing of the rivet is considerable for such a device, especially because it requires the maintenance of low manufacturing tolerances with reference to the means for pulling the rivet. Also, this arrangement requires a large structure for the entire assembly.

GB-A-1,128,442 shows a device for producing a riveted joint with means for the driving of a rivet having a rivet jacket and a rivet pin guided through the rivet jacket through workpieces to be joined and with means for the pulling of the rivet, whereby the means for the driving-in of the rivet act on the rivet pin and have a firing bolt in a cylindrical part and a cylindrical striking member arranged between the rivet and the firing bolt,

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which has a shoulder on which the firing bolt impacts. When during insertion into the device the rivet with its rivet pin is guided in insufficiently far to form contact on a contact strip of the striking member and/or through the manipulation of the device and the movements of the rivet pin connected therewith is moved away from the contact strip, during the driving-in process there occurs an impact of the striking member on the rivet pin. This frequently leads to an undesired deformation of the rivet pin and/or to damage of the striking member.

DE 295 14 392 U1 shows a rivet in which the rivet jacket is stopped on the rivet pin, wherein especially the rivet jacket is stopped between convexities constructed between the rivet pin and the rivet head, and the rivet pin has a conical point on its first end turned toward the workpieces. With driving in of such a rivet the driving-in force is exerted on the rivet jacket. With the use of a such a rivet with a device of the invention, in which the means for the driving-in of the rivet work on the rivet pin, the rivet pin is forced through the rivet jacket, whereupon no riveted joint can be produced.

The present invention therefore addresses the problem of preparing a device for producing a riveted joint which overcomes the drawbacks of the state of the art and especially which prevents the deformation of the rivet pin and/or of the striking member and thus provides a higher level of operational security and a longer life of the device. Therefore the device is to be produced at low cost and guarantees reliable operation. The outlay for the construction for the preparation of the means for the pulling and

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means for the firing of the rivet is thus to be as small as possible, and especially a realization is to be facilitated which is of as small as possible structural dimensions. Also, a rivet which can be processed using this device is to be prepared for use.

The problem is solved by the device disclosed in Claim 1. A suitable rivet is specified in the following claim. Special embodiments of the invention are specified in the dependent claims.

The problem is solved in that the striking member is held in the cylindrical part by a flexible element, especially by a first helical spring in axial contact on the rivet pin. This arrangement provides the advantage that the striking member already engages on the rivet pin when the firing bolt impacts on the striking member. Thus any damage, particularly bending, of the rivet pin and of the striking member is reliably prevented on the basis of an impacting of the striking member on the rivet pin. Furthermore then also a dropping of the torn-off rivet pin into the firing channel is prevented, and the device can be operated in any position, and particularly rivets can even be arranged facing vertically upward.

Owing to the fact that the means for the driving-in or firing of the rivet act on the rivet pin, the means for the pulling of the rivet can advantageously engage in firing direction before the means for the firing of the rivet on the rivet pin. The constructive configuration of space allowed for the realization of the means for pulling the rivet is thus greater and a corresponding device of small dimensions can be easily realized. The firing of the rivet with acting upon the rivet pin then increases the reliability of the rivet joint being produced, since a certain penetration of the workpieces to be joined

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-2-

.... This type of rivet is frequently also called a "blind rivet". EP 0 302 128 B1 shows a tool for the pulling or setting of blind rivets. Also with use of such a tool a preliminary borehole and insertion of the blind rivet are still required.

WO 95/05255 shows a device for production of a riveted joint with pneumatically driven means for the firing of a rivet through the workpieces to be joined and pneumatically driven means for the subsequent pulling of the rivet. The means for the firing of the rivet in this case incorporate a conically tapering, hollow cylindrical driving-in part on the striking head of the rivet jacket. The rivet pin is guided through an opening in the striking surface of the driving-in part which is turned toward the striking head of the rivet in the interior of the driving-in part, and at that point is picked up by the means arranged to the rear of the driving-in part in the firing direction for the pulling of the rivet. The outlay for construction required by the arrangement of the means for the pulling of the rivet within the hollow cylindrical volume formed by the means for the firing of the rivet is considerable for such a device, especially because it requires the maintenance of low manufacturing tolerances with reference to the means for pulling the rivet. Also, this arrangement requires a large structure for the entire assembly.

GB-A-1,128,442 shows a device for producing a riveted joint with means for the driving of a rivet having a rivet jacket and a rivet pin guided through the rivet jacket through workpieces to be joined and with means for the pulling of the rivet, whereby the means for the driving-in of the rivet act on the rivet pin and have a firing bolt in a cylindrical part and a cylindrical striking member arranged between the rivet and the firing bolt,

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is guaranteed by means of the rivet pin. The means for the firing and means for the pulling of the rivet can be powered pneumatically, hydraulically, magnetically, electrically, piezoelectrically or with use of some means of explosion.

Owing to the fact of the "interposition" of a cylindrical striking member between the firing bolt and the rivet the reliability of the firing process and with that the reliability of the riveted joint itself is heightened, the striking member can thus be made up of a first segment of which the diameter is adapted to the diameter of the firing channel and a second segment of which the smaller diameter is adapted to the diameter of the rivet pin, and particularly can be of approximately identical diameter up to 1.5-times the diameter of the rivet pin.

The device of Claim 2 provides the advantage that the reliability of the firing process is even further heightened by having the centering device adapted to the for example trough-like or depressed shape of the end of the rivet pin which is adjacent to the striking member. Of particular importance, the traditionally desirable rectangular alignment of the rivet pin in relation to the workpieces to be joined and the corresponding guiding of the rivet during the firing process is guaranteed .

The device according to Claim 3 offers the advantage that the movement of the striking member at the end of the firing process is smoothly suppressed by the flexible buffer element and especially does not impinge on the end of the preferably metallic firing channel. The service life of the device is thus significantly increased. The buffer element engages preferably on an annular shoulder at the end of the firing channel, which is formed by an opening in the firing channel,

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and for example can be embodied as helical spring, disk spring or rubber or plastic washer.

The device according to Claim 4 offers the advantage that the firing channel can be made easily accessible as a result of the two-part configuration of the firing channel being formed by a hollow piston and a connecting member which preferably are screwed together, and especially in that case the striking member can be exchanged when necessary.

The device according to Claim 5 offers the advantage that not only is the guiding of the rivet pin during the firing and pulling process obtained through the end piece, but that the end piece simultaneously executes a spreading of the clamping jaws during the firing process and with that allows a friction-free passage of the rivet pin and if necessary of the striking member through the clamping jaws during the firing process. Any damage to the clamping jaws and potentially to the striking member is simultaneously and reliably prevented by the rivet pin during the firing process. Also the introduction of a new rivet is simplified by the spreading of the clamping jaws. The second flexible element can be configured as a helical spring. Alternatively to that for example a disk spring or a rubber or plastic washer can be used.

The device according to Claim 6 offers the advantage that by having the piston, joining member and clamp sheathing connected with one another, preferably by being screwed together with one another, a pulling of the rivet pin by means of the stress of the pressure of the piston counter to the force effect of a flexible element, preferably a helical screw with high elasticity constant, a reliable

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pulling of the rivet and with that a reliable production of the riveted joint are guaranteed. The pressure is preferably applied by using hydraulic pressure in order to generate the required high pressure forces.

The device as in Claim 7 offers the advantage that the device requires only one auxiliary connection, in the form of a compressed air connection. The hydraulic pressure is generated through a pneumatic/hydraulic pressure converter. The rivet is fired pneumatically; the rivet is pulled off hydraulically. The entire riveting process including firing and pulling is controlled by a three-stage pneumatic switch element. The pneumatic/hydraulic pressure converter the same as the rapid evacuation valve is preferably mounted in a handle of the device.

A rivet according to Claim 8 is provided for use in the device according to the invention. With the pyramid-shaped point of the rivet pin, for example four cutting edges are formed, which simplify penetration of the workpieces. By the provision of catch means directed toward the point of the rivet, any relative movement of the rivet in relation to the rivet jacket, especially during the firing process of the rivet, is reliably prevented. The catching means could thus for example be realized by pins projecting radially and arranged distributed around the periphery of the rivet pin or by truncated conical partial segments of the rivet pin produced by rollers and arranged in axial alignment one behind the other.

Owing to the fact that the rivet jacket is connected tightly with the rivet pin, and preferably is extruded thereon, the rivet pin will not be moved, or at least will not be moved remarkably relative to the rivet jacket especially during the firing process

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advantageous with use of the rivet in a device according to the invention, since with the device according to the invention the means for firing the rivet act on the rivet pin. The rivet pin is preferably of steel or stainless steel. The rivet jacket can likewise be of steel or stainless steel or alternatively of an aluminum or copper alloy. Upon deformation of the point, penetration of the workpieces is still possible even when using low firing energy. The point can be configured conical or if desired can be ogival, and especially the point can also have one or more cutting edges. The point angle is preferably configured in a range of 30 to 60°.

The rivet as in Claim 9 offers the advantage that cooperation with the centering device on the striking member is specifically guaranteed by the tapering second end of the rivet pin. A configuration of the second end in the shape of a pyramid is advantageously obtained by suitable separation of a rivet pin from a rod-shaped starting material.

Other advantages, features and individual points relating to the invention are disclosed in the dependent claims as well as in the following description with reference to the drawings showing one exemplary embodiment in some detail. Thus the selected features indicated in the claims and in the description can be protected individually in turn in and of themselves or in any desired combination considered as relating to the invention.

Fig. 1 shows a section through the head part of the device according to the invention,

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- Fig. 2 shows a section through the handle of the device according to the invention,
- Fig. 3 shows a diagrammatic and partially cutout view of the entire device according to the invention, and
- Fig. 4 shows a rivet for use in the device according to the invention.

Fig. 1 shows a section through the head part of the device according to the invention, which device is responsible for the firing and pulling of the rivet. The housing 1 of the device is represented at the right edge of the drawing, on which housing with use of a first packing O-ring 2 and a glass shield 24 the first cylinder 22 is screwed on by means of cylindrical screw 6 and supporting disks or washers 23. Likewise on the right edge of the drawing is represented the pneumatic cylinder 58 with the firing bolt 25 and the first buffer 50. Firing channel 70 extends in axial extension of firing bolt 25 and is /formed/ by the centering piece 45,

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Patent Claims

1. Device for producing a riveted joint with means (21, 25) for the driving-in of a rivet (14) having a rivet jacket (14a) and a rivet pin (14b) guided by the rivet jacket (14a) through workpieces to be joined and with means for the pulling of the rivet (14), whereby the means (21, 25) for the driving-in of the rivet (14) act on the rivet pin (14b) and the means for the driving-in of the rivet (14) into a cylindrical part, especially into a firing channel (70), include a firing bolt (25) and a cylindrical striking member (21) arranged between the rivet (14) and the firing bolt (25), on which impacts the firing bolt (25), **characterized in that** the striking member (21) is held in the cylindrical part by a first flexible element, especially by a first helical spring (51), in axial contact on the rivet pin.
2. Device as in Claim 1, characterized in that the striking member (21) has a centering device for the rivet pin (14b) on its end turned toward the rivet (14).
3. Device as in Claim 1 or 2, characterized in that at one end of the cylindrical part turned toward the rivet (14) is arranged a flexible buffer element (49), which buffers the movement of the striking member (21) during the driving-in of the rivet (14).
4. Device as in one of the Claims 1 to 3, characterized in that the cylindrical part is formed by boreholes

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in alignment in a piston (20) and in a joining member (18) joining with the piston (20).

5. Device as in Claim 4, characterized in that the means for pulling the rivet (14) include a clamp sheathing (4) connected with the joining member (18), which surrounds the clamping jaws (3) arranged around the rivet pin (14b), and that the clamp sheathing (4) and the joining member (18) are guided in a guiding sleeve (16), in the axial end of which turned toward the rivet (14) is inserted an end piece (15) provided with a borehole in the center to receive the rivet pin (14b), which end piece spreads the clamping jaws (3) engaging on it before and during the driving-in under the effect of a second flexible element (7).
6. Device as in Claim 5, characterized in that the piston (20) can be moved in a cylinder (22) connected with the guiding sleeve (16) during pulling of the rivet (14), the piston being moved counter to the driving-in direction through pressure application coming from the piston (20) counter to the effect of the force of a third flexible element (8).
7. Device as in one of the Claims 4 to 6, characterized in that the device has a compressed air connection (68) and a multi-stage pneumatic switch element (59, 60, 61), which in a first switch stage fires the firing bolt (25), in a second switch stage feeds the compressed air to a pneumatic/hydraulic pressure converter preferably mounted in a handle (71) of the device, which makes ready the pressure stress application of the piston (20) during pulling of the rivet, and in a third switch stage evacuates the pneumatic/

hydraulic pressure converter by means of a rapid evacuation valve.

8. Rivet for use in a device for producing a riveted joint with means (21, 25) for the driving-in of a rivet (14) having a rivet jacket (14a) and a rivet pin (14b) guided through the rivet jacket (14a) through workpieces to be joined and with means for the pulling of the rivet (14), whereby the rivet pin (14b) is connected tightly with the rivet jacket (14a), characterized in that the rivet pin (14b) at its first end turned toward the workpieces has a pyramid-shaped point (14c) and that the rivet pin (14b) in the area of the rivet jacket (14a) has catching means directed toward the point (14c) of the rivet (14).
9. Rivet as in Claim 8, characterized in that the rivet pin (14b) at its second end (14g) more distant from the workpieces is tapered and preferably is configured in pyramid shape.

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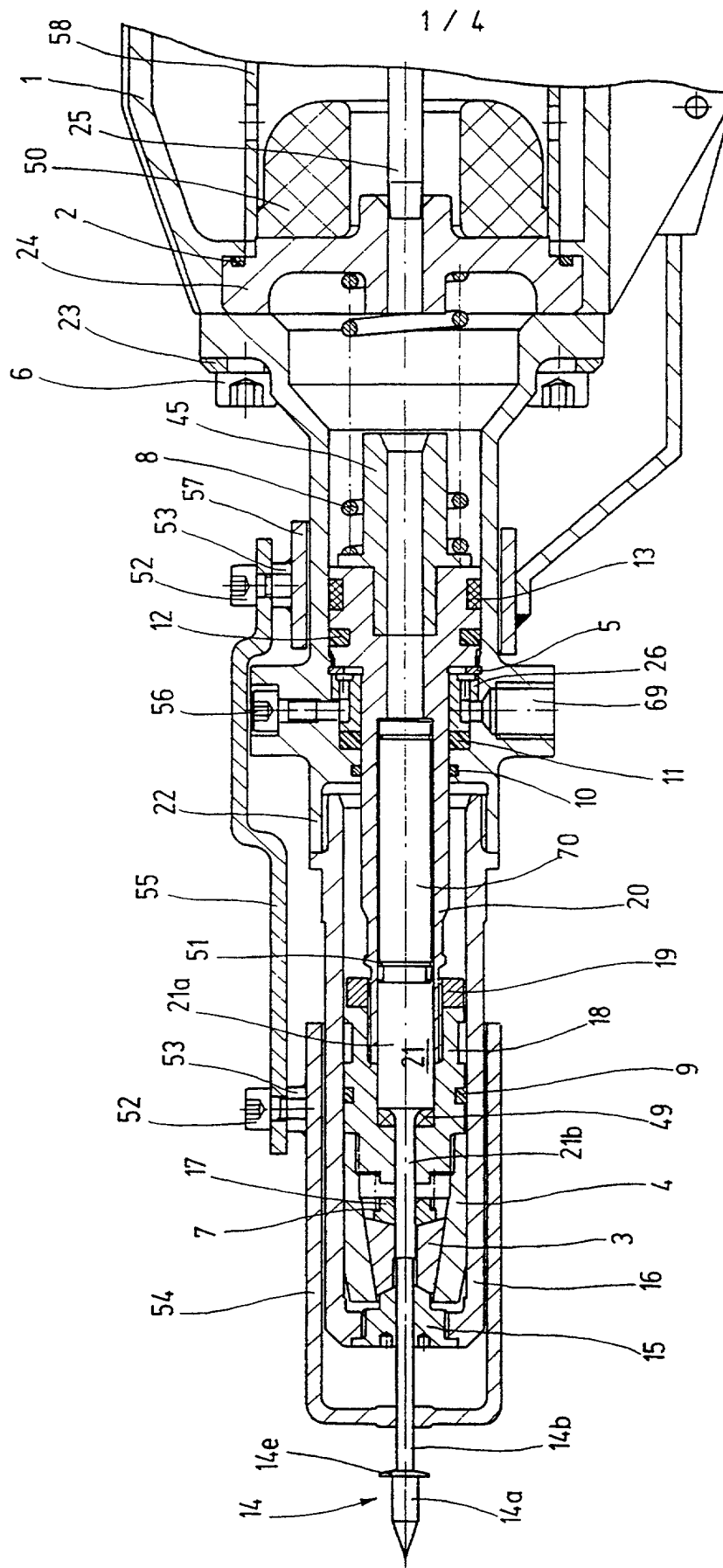
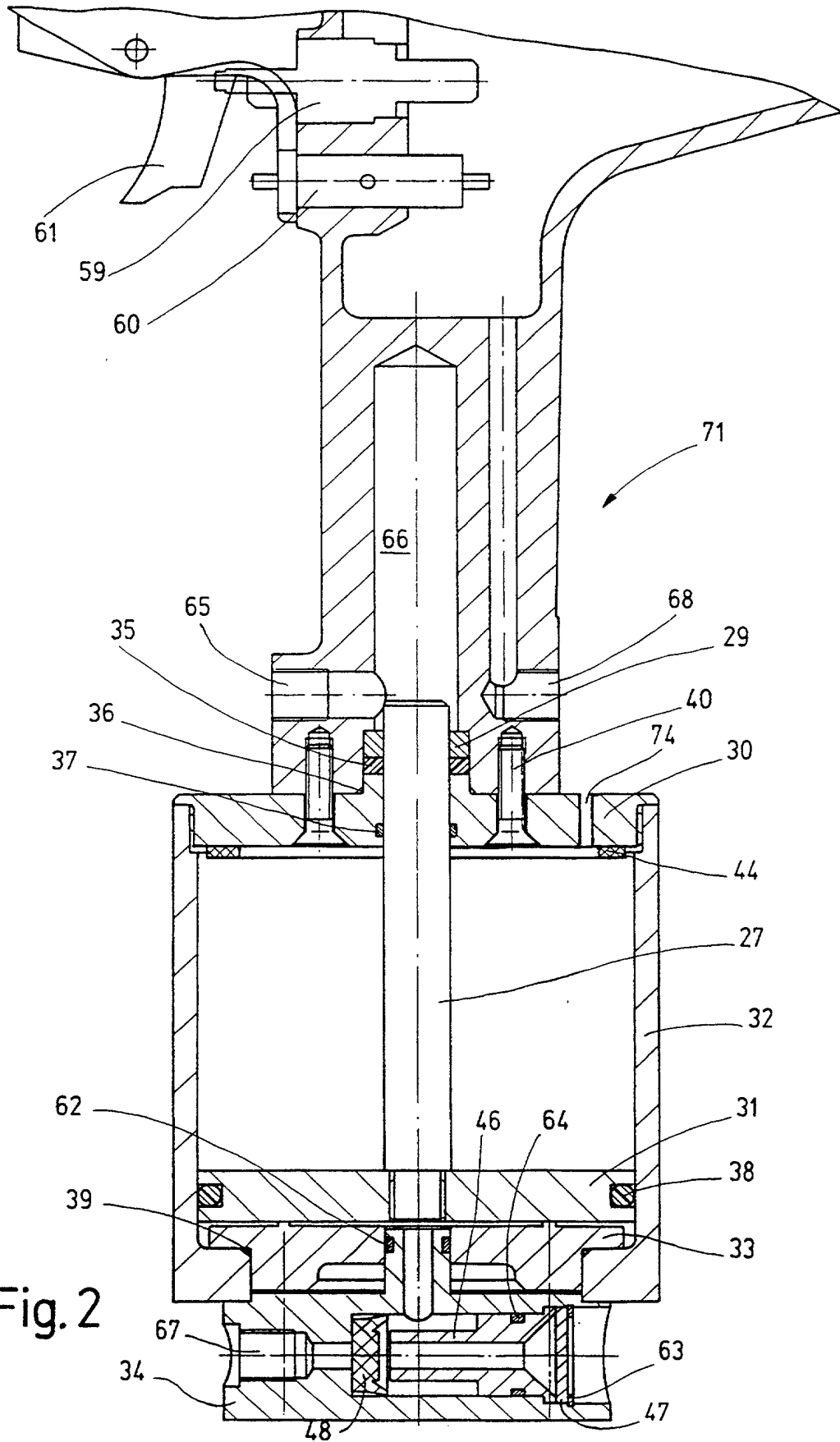
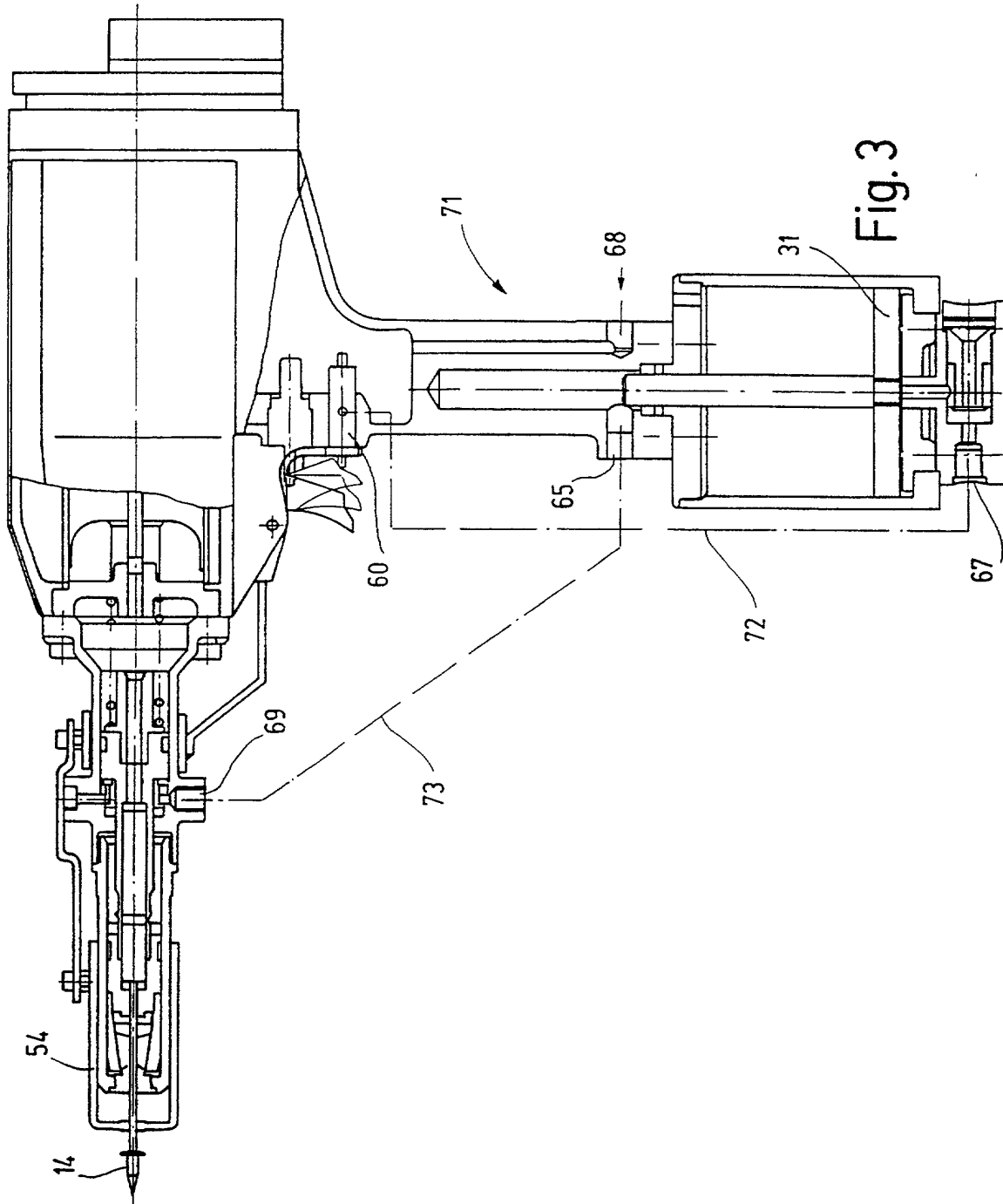


Fig. 1

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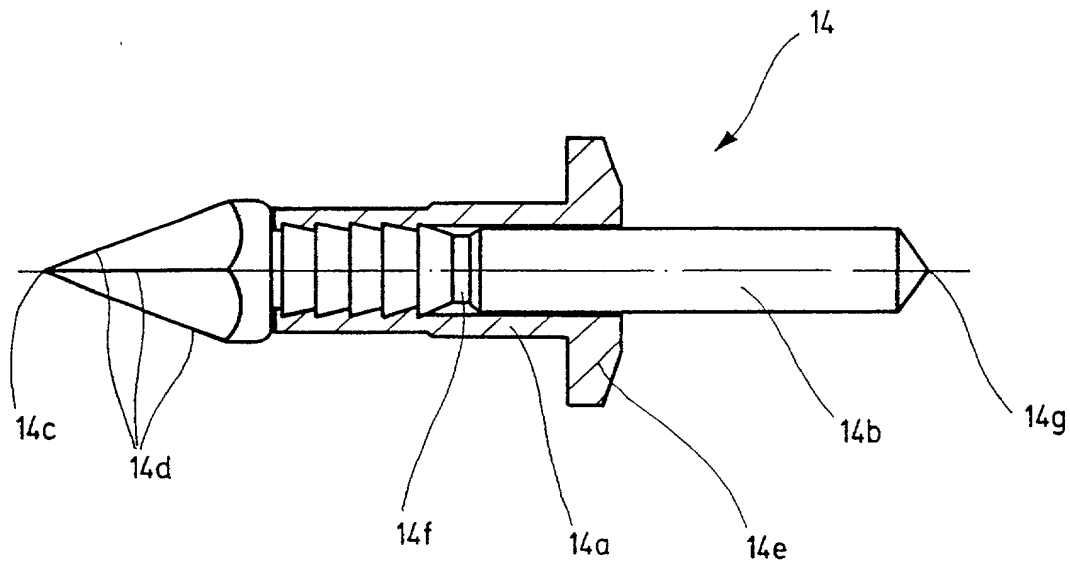


Fig. 4

Declaration and Power of Attorney for Patent Application

Erklärung für Patentanmeldungen mit Vollmacht

German Language Declaration

Als nachstehend benannter Erfinder erkläre ich hiermit an Eides Statt:

daß mein Wohnsitz, meine Postanschrift und meine Staatsangehörigkeit den im nachstehenden nach meinem Namen aufgeführten Angaben entsprechen, daß ich nach bestem Wissen der ursprüngliche, erste und alleinige Erfinder (falls nachstehend nur ein Name angegeben ist) oder ein ursprünglicher, erster und Miterfinder (falls nachstehend mehrere Namen aufgeführt sind) des Gegenstandes bin, für den dieser Antrag gestellt wird und für den ein Patent für die Erfindung mit folgendem Titel beantragt wird:

As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated next to my name.

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled

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deren Beschreibung hier beigelegt ist, es sei denn (in diesem Falle Zutreffendes bitte ankreuzen), diese Erfindung

- ☐ wurde angemeldet am _____ unter der US-Anmeldenummer oder unter der Internationalen Anmeldenummer im Rahmen des Vertrags über die Zusammenarbeit auf dem Gebiet des Patentwesens (PCT) _____ und am _____ abgeändert (falls zutreffend).

the specification of which is attached hereto unless the following box is checked:

- ☒ was filed on June 4, 1999 as United States Application Number or PCT International Application Number PCT/EP99/03862 and was amended on _____ (if applicable).

Ich bestätige hiermit, daß ich den Inhalt der oben angegebenen Patentanmeldung, einschließlich der Ansprüche, die eventuell durch einen oben erwähnten Zusatzantrag abgeändert wurde, durchgesehen und verstanden habe.

I hereby state that I have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment referred to above.

Ich erkenne meine Pflicht zur Offenbarung jeglicher Informationen an, die zur Prüfung der Patentfähigkeit in Einklang mit Titel 37, Code of Federal Regulations, § 1.56 von Belang sind.

I acknowledge the duty to disclose information which is material to patentability as defined in Title 37, Code of Federal Regulations, § 1.56.

PTO/SB/103 (8-96)

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Ich beanspruche hiermit ausländische Prioritätsvorteile gemäß Title 35, US-Code, § 119 (a)-(d), bzw. § 365(b) aller unten aufgeführten Auslandsanmeldungen für Patente oder Erfinderurkunden, oder § 365(a) aller PCT internationalen Anmeldungen, welche wenigstens ein Land ausser den Vereinigten Staaten von Amerika benennen, und habe nachstehend durch ankreuzen sämtliche Auslandsanmeldungen für Patente bzw. Erfinderurkunden oder PCT internationale Anmeldungen angegeben, deren Anmeldetag dem der Anmeldung, für welche Priorität beansprucht wird, vorangeht.

Prior Foreign Applications
(Frühere ausländische Anmeldungen)

198 26 157.8

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(Number)
(Nummer)

(Country)
(Land)

(Number)
(Nummer)

(Country)
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(Aktenzeichen)

(Filing Date)
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(Aktenzeichen)

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(Aktenzeichen)

(Filing Date)
(Anmeldetag)

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Priority Not Claimed
Priorität nicht beansprucht

12 June 1998

(Day/Month/Year Filed)
(Tag/Monat/Jahr der Anmeldung)

(Day/Month/Year Filed)
(Tag/Monat/Jahr der Anmeldung)

I hereby claim the benefit under Title 35, United States Code, § 119(e) of any United States provisional application(s) listed below

I hereby claim the benefit under Title 35, United States Code, § 120 of any United States application(s), or § 365(c) of any PCT International application designating the United States, listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States or PCT International application in the manner provided by the first paragraph of Title 35, United States Code, § 112, I acknowledge the duty to disclose information which is material to patentability as defined in Title 37, Code of Federal Regulations, § 1.56 which became available between the filing date of the prior application and the national or PCT International filing date of this application.

(Status) (patented, pending, abandoned)
(Status) (patentiert, schwebend, aufgegeben)

(Status) (patented, pending, abandoned)
(Status) (patentiert, schwebend, aufgegeben)

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

PTO/SB/103 (8-96)

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VERTRETUNGSVOLMACHT: Als benannter Erfinder beauftrage ich hiermit den (die) nachstehend aufgeführten Patentanwalt (Patentanwälte) und/oder Vertreter mit der Verfolgung der vorliegenden Patentanmeldung sowie mit der Abwicklung aller damit verbundenen Angelegenheiten vor dem US-Patent- und Markenamt: (Name(n) und Registrationsnummer(n) auflisten)

8

POWER OF ATTORNEY: As a named inventor, I hereby appoint the following attorney(s) and/or agent(s) to prosecute this application and transact all business in the Patent and Trademark Office connected therewith: (list name and registration number)

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Robert H. Berdo Reg. No. 19,415 Dean H. Nakamura Reg. No. 33,861
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Vor- und Zuname des einzigen oder ersten Erfinders 1 - ∞	Full name of sole or first inventor <u>Sven Röthe</u>
Unterschrift des Erfinders Datum	Inventor's signature <u>S. Röthe</u> Date <u>30.11.00</u>
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Staatsangehörigkeit	Citizenship <u>German</u>
Postanschrift	Post Office Address <u>Coswiger Landstrasse 13</u>
	<u>D-06886, Lutherstadt Wittenberg, Germany</u>
Vor- und Zuname des zweiten Miterfinders (falls zutreffend)	Full name of second joint inventor, if any <u>Klaus Wirth</u>
Unterschrift des zweiten Erfinders Datum 2 - ∞	Second Inventor's signature <u>Klaus Wirth</u> Date <u>30.11.00</u>
Wohnsitz	Residence <u>Tettnang, Germany DEX</u>
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(Im Falle dritter und weiterer Miterfinder sind die entsprechenden Informationen und Unterschriften hinzuzufügen.)

(Supply similar information and signature for third and subsequent joint inventors.)